



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5955
Job Sheet 179525



Part No: D5955

Job Qty: 6 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/20/18

Job Tracking No:

Due Date: 7/24/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG-REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:F ecn826 06.12.06 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/24/18	7/24/18	0.00	0.00	Start Up Machining-4		SBL 18/07/12
100	CNC Vertical Machining	6 pcs	7/24/18	7/24/18	0.32	16.67	HAAS1-5		SBL 18/07/13
110	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC1		SBL 18/07/13
120	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC8 Machining-4		SBL 18/07/14
130	HandFinish	6 pcs	7/24/18	7/24/18	0.00	0.52	HandFinish1		SA 18-07-16
140	Powdercoat	6 pcs	7/24/18	7/24/18	0.00	0.28	Powdercoat1		SBL 18-7-17
150	QC	6 pcs	7/24/18	7/24/18	0.00	0.00	QC3		JUL 24 2018
160	Packaging	6 pcs	7/24/18	7/24/18	0.00	0.00	Packaging3-2		JUL 24 2018
170	QC21-SA	6 Ea	7/24/18	7/24/18	0.00	0.00	QC21		JUL 24 2018

Part Op 100 - 1-Machine as per folio D5955, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMMA018.

140 - START TIME: 2:30 O.U.T. 3:00 FINISH 3:00.

M138639

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-013	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	5017338 + 5082697

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-013	6	12	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermofforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	
Date: _____		Step #: _____		QTY Effective: _____	
Description Work Order Deviation				Disposition	
Completed By				MRB (QSI042) Approval	
Lead hand / Supervisor Approval Verification				QC / QA Coordinator Approval	

Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	
Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	
Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Mistread ☐ Turning Sequence ☐	

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 Hawkesbury, ON K6A 1K7
 CANADA
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 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 07/13/18



Container No: S091510
 Part: D5955
 Job No: 179525
 Serial No/Batch: S091510
 Revision:
 Inspector:
 Exp Date:
 Instructions:

DART AEROSPACE LTD		Work Order: 179525
Description: Outer Aft Saddle		Part Number: D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		438	438	438	438		
B	1.745	1.755		1750	1750	1750	1750		
C	5.245	5.255		5250	5250	5250	5250		
D	6.995	7.005		7000	7000	7000	7000		
E	5.240	5.260		5250	5250	5250	5250		
F	4.745	4.755		4750	4750	4750	4750		
G	0.315	0.322		316	316	316	316		
H	1.522	1.532		1528	1528	1527	1527		
I	3.048	3.058		3054	3053	3053	3053		
J	4.575	4.585		4581	4580	4580	4580		
K	0.315	0.322		316	316	316	316		
L	0.495	0.505		500	500	500	500		
M	0.490	0.510		497	501	501	501		
N	1.865	1.885		1875	1875	1875	1875		
O	7.990	8.010		8000	8000	8000	8000		
P	2.240	2.260		2250	2250	2250	2250		
Q	0.307	0.312		311	310	311	311		
R	0.760	0.765		760	766	760	760		
S	0.490	0.510		504	500	501	5000		
T	1.625	1.645		1625	1625	1625	1625		
U	2.000	2.020		2000	2000	2000	2000		
V	0.023	0.043		033	033	033	033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DAS
Date: 57 18/07/13
9-89

Audited by: <i>[Signature]</i>
Date: 18/07/14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	
G	08.08.05	Dimension K revised	KJ/DD	

DART AEROSPACE LTD		Work Order: 179525	
Description: Outer Aft Saddle		Part Number: D5955	
Inspection Dwg: D5955		Rev: B	
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5 th	6 th	3	4		
A	0.438	0.443		.438	.438				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.240	5.260		5.250	5.250				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.316	.316				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.580	4.580				
K	0.315	0.322		.316	.316				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.501	.501				
N	1.865	1.885		1.875	1.875				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.311	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.502	.500				
T	1.625	1.645		1.625	1.625				
U	2.000	2.020		2.000	2.000				
V	0.023	0.043							
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by:	mg
Date:	16/09/14

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
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